

Work Order ID 127176

127176

Page 1

Monday, December 15, 2014 8:11:04 AM

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 12/15/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 14-12-15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100	Large Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

100
 Large Fab
 Large Fab

Memo 0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: B125054

PLEASE NOTE SEE DWG
 IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG

1x CC 15-1-7

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
-----	--	------	--	--	--	--	--	--	--

110
 QC
 Quality Control

Memo 0.00

JAN 08 2015

DAS
24
9-89

Work Order ID 127176

Monday, December 15, 2014 8:11:04 AM

127176

Page 2

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 12/15/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/15/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							DAS 24 9-89
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

1 of 15-1-8, 233

Work Order ID 127176

Monday, December 15, 2014 8:11:04 AM

127176

Page 3

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 12/15/2014 Start Qty: 1.00 ***1*** Cust Item ID: .
 Required Date: 12/15/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M/29 808.</i>	0.00				<i>1</i>	<i>15-1-8.</i>		<i>93 08</i>
Powdercoat	Memo								
Powder Coating	1- Plug holes prior to								
	1ST COAT:								
	START TIME: <i>11:30</i>								
	OVEN TEMPERATURE: <i>400</i>								
	FINISH TIME: <i>12:00</i>								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
						<i>14</i>	<i>15/12/14</i>		<i>DAS 15 9-00</i>

Work Order ID 127176

Monday, December 15, 2014 8:11:04 AM

127176

Page 4

Item ID: D2221

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Base Assembly

Stop ***NS2***

Start Date: 12/15/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/15/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Identify as per dwg & Stock Location: WV

0.00 D350-607-041A/B127176

150

Packaging

Memo

0.00

Packaging

1x 15/01/09

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 15-01-09MF
15-01-09

Picklist Print

Monday, December 15, 2014 8:11:09 AM

Page 1

Work Order ID: 127176

127176

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	12.0000	1	1		15-1-7	
									**				
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	12							
					121579	12							
D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	8.0000	2	2		15-1-7	
									**				
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	8							
					120258	8							
D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	16.0000	1	1		15-1-7	
									**				
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					WA004	16							
					121991	1							
					125057	8							
					98039	7							

Picklist Print

Monday, December 15, 2014 8:11:09 AM

Work Order ID: 127176

127176

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each 44.0000 2 2

D2232-3

Basket Hinge

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

44

B105884 →

(2x)

101778

20

105884

4

115847

20

D2235-1 Manufactured No

100 Each 8.0000 2 2

D2235-1

Basket Rib

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

8

110064

2

120139

6

(2x)

D2581 Manufactured No

100 Each 98.0000 2 2

D2581

Mounting Bracket

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

98

102265

58

122730

40

(2x)

D3442-1 Manufactured No

100 Each 26.0000 2 2

D3442-1

Shim

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

26

121484

22

99654

4

(2x)

Picklist Print

Monday, December 15, 2014 8:11:10 AM

Page 3

Work Order ID: 127176

127176

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 12/15/2014

Required Date: 12/15/2014

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No

100 Each 4.0000 2 2

D3825-041

Rib Assembly (Basket End)

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

4

121676

4

(2x)

D3826-041 Manufactured No

100 Each 6.0000 2 2

D3826-041

Rib / Gusset Assembly

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

6

125170

6

(2x)

D3827-041 Manufactured No

100 Each 2.0000 1 1

D3827-041

Rib Assembly (Inboard)

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA004

2

B125361

(1x)

120658

2

D3832-1 Manufactured No

100 Each 0.0000 1 1

D3832-1

Mesh (Base)

**

CC 15-1-7

D3833-1 Manufactured No

100 Each 15.0000 2 2

D3833-1

Mesh (Base End Face)

**

CC 15-1-7

Location

Loc Qty

Loc Code

WA006

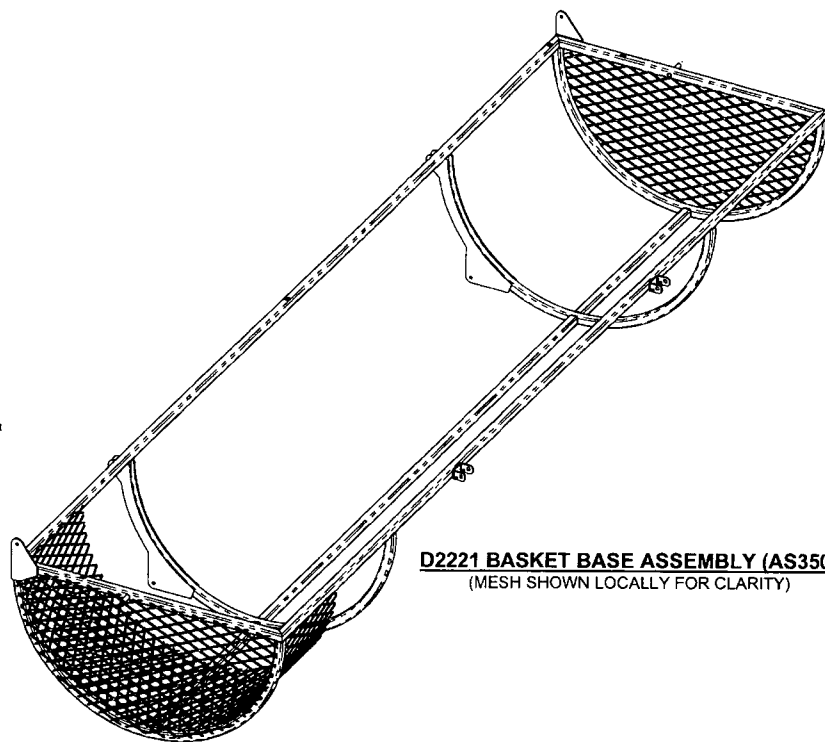
15

B114241

(2x)

105890

15



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 127176 M.C.S
14-12-15

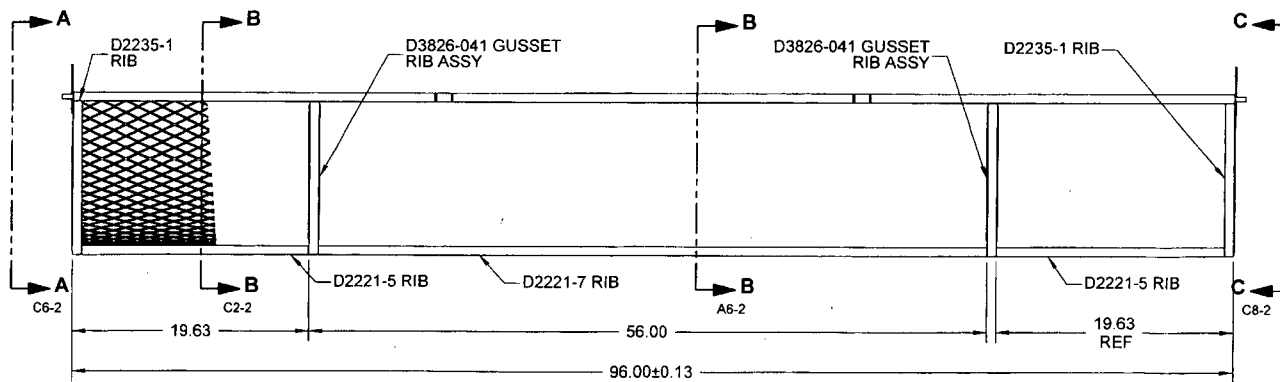
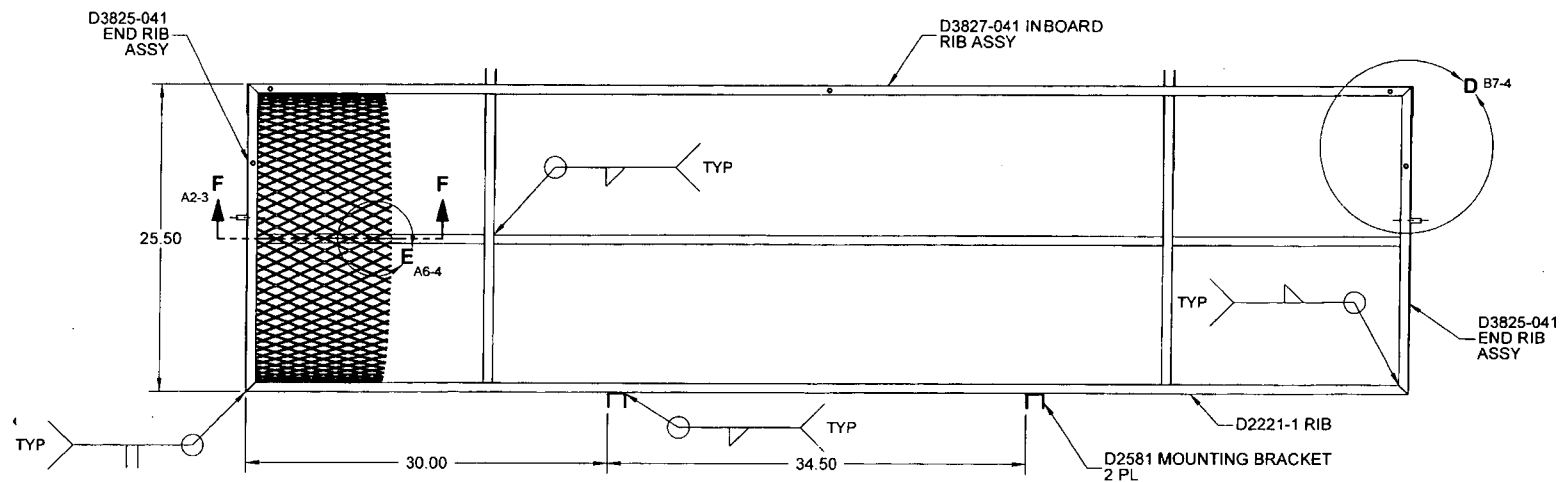
RELEASED
08/11/15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

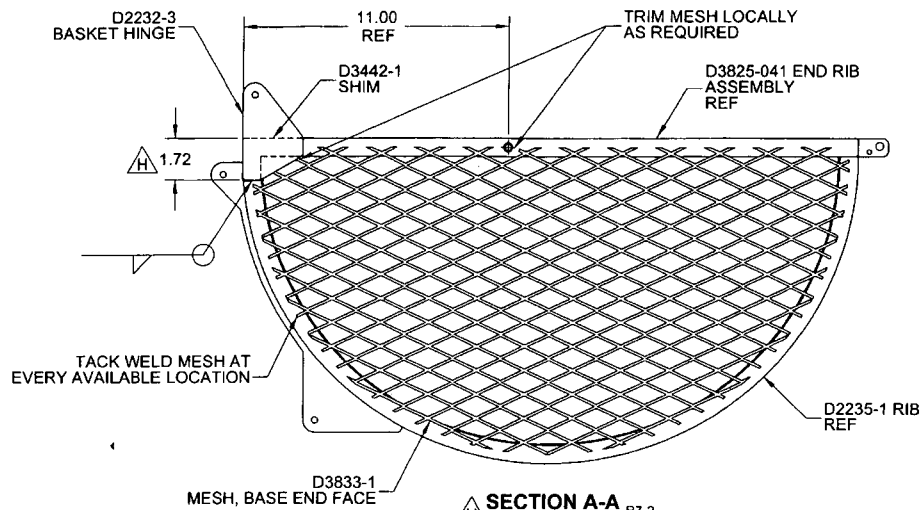
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL, TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2, SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



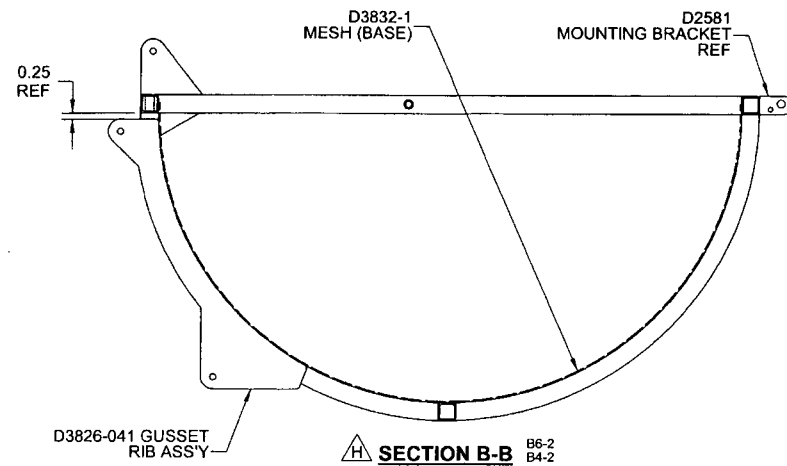
D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

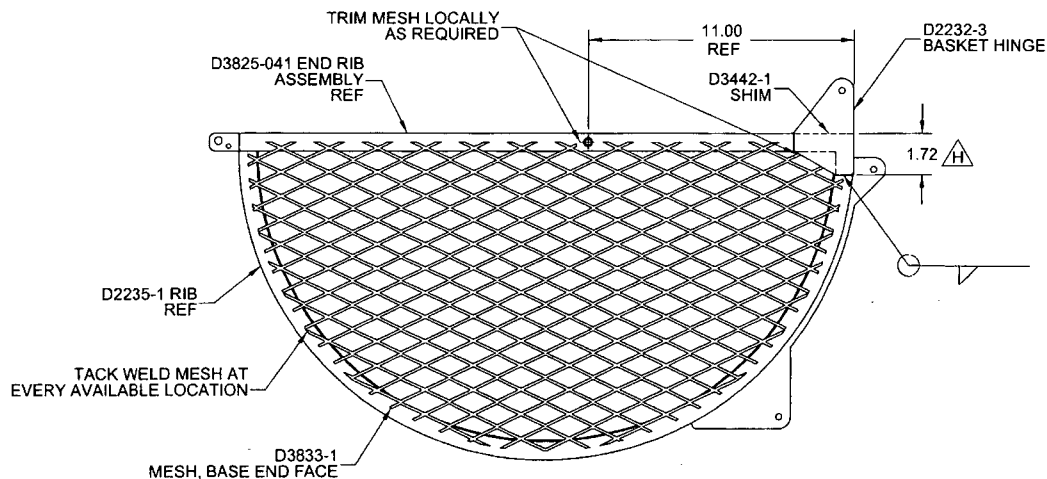
DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A B7-2
SCALE 2X



SECTION B-B B6-2
B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)
SCALE 2X



SECTION C-C B2-2
SCALE 2X

RELEASE
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 3 OF 5	
APPROVED	1/1	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

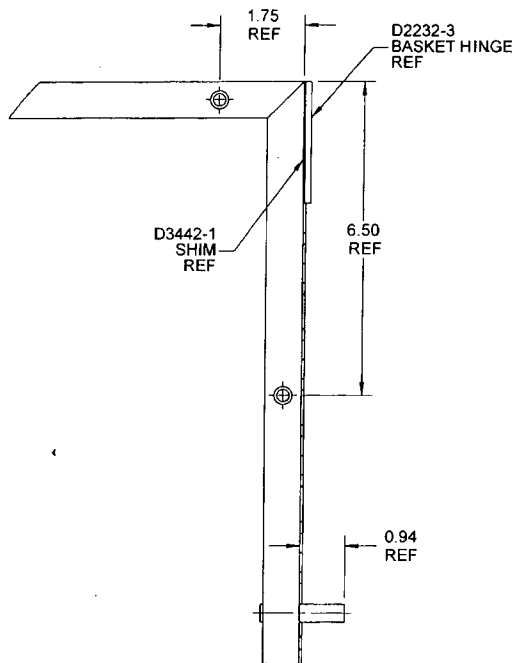
8 7 6 5 4 3 2 1

D

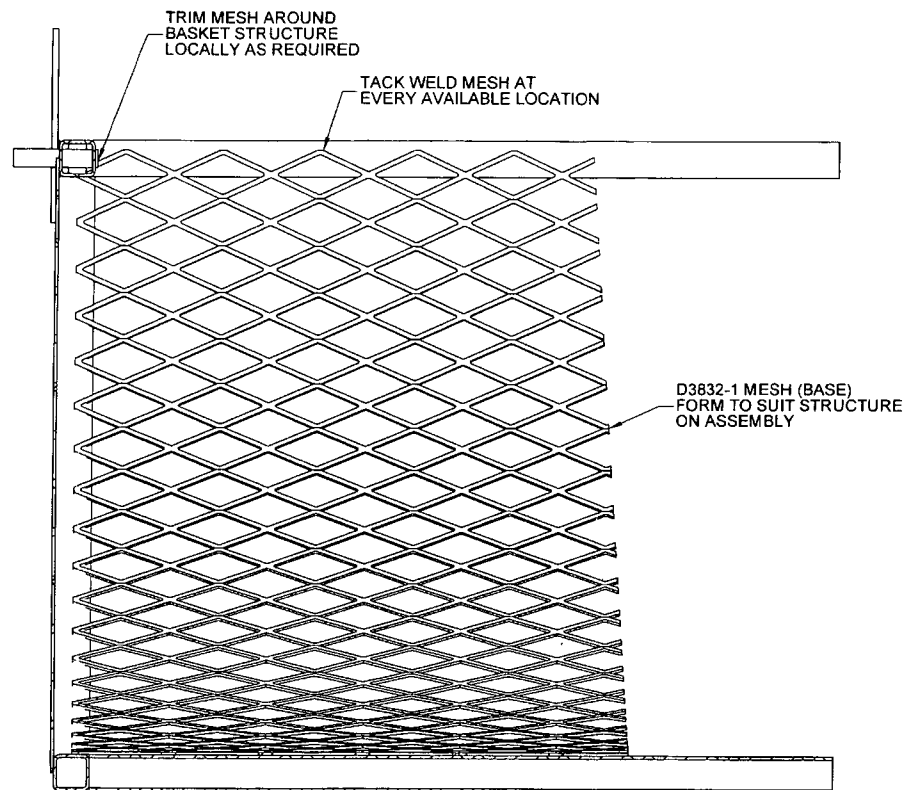
C

B

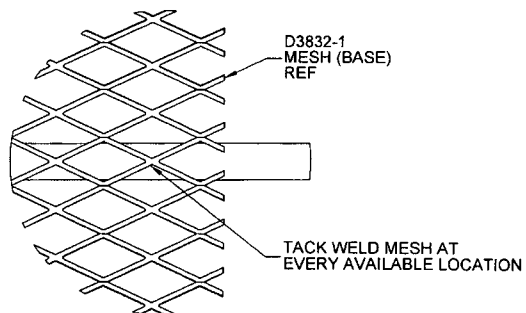
A



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2

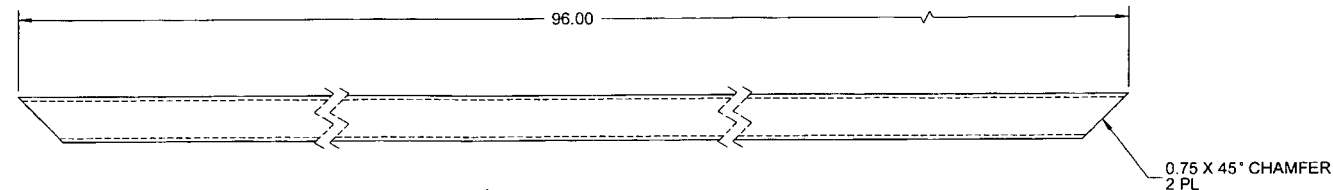
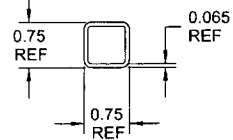
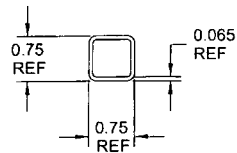


DETAIL E
SCALE 4X C6-2

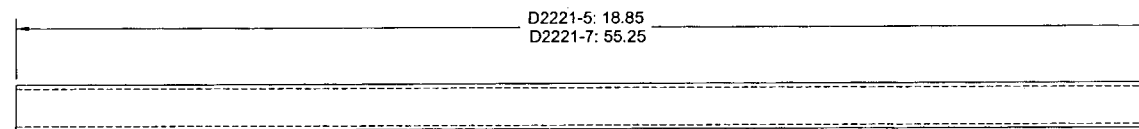
RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	14/3	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	14/10	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	